



Dart Aerospace Ltd.
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Canada

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D3200-1
Job Sheet 194885



Part No: D3200-1

Job Qty: 20 pcs

Part Name: Door Post Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/9/19

Job Tracking No:

Due Date: 6/24/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	6/24/19	6/24/19	0.00	0.18	Bandsaw - 1	52	19/05/31 19/05/31
110	HAAS 4 Axis - B4B	20 pcs	6/24/19	6/24/19	0.07	6.58	HAAS - 1 - B4B	52	
							HAAS - 2 - B4B	52	
							HAAS - 3 - B4B	9-89	
							HAAS - 4 - B4B		
130	QC 8	20 pcs	6/24/19	6/24/19	0.00	0.00	QC 8 - 12		mL 19/06/05
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Packaging 3-1 - Stock - B4B	20 pcs	6/24/19	6/24/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		



Container No: S186254



Part: D3200-1

Job No: 194885

Serial No/Batch: S186254

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/31/19

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				Packaging 3 - 3 - B4B					
				Packaging 3 - 4 - B4B	ST02207 JUN 05 2019				
				Packaging 3 - 5 - B4B					
				Packaging 3 - 6 - B4B					
				Packaging 3 - 7 - B4B					
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				150 QC 21 - SA	20 pcs	6/24/19	0.00 0.00	QC 21 - SA - 21	DAG
								QC 21 - SA - 70	21
QC 21 - SA - 53	9-89								

Part Op 100 - (Bandsaw) Cut blank: 2.700" x 2.700

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3200-1 as per Folio FA337 and Dwg D3200

130 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

JUN 05 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	1 sf (.05 ea)	100-Bandsaw - 1	FM136453 x11 8413598 100 9

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MUHMWB10	1	1,025	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Post Block	0.196inches + 0.005 - 0.000	0.201 0.196	0.192	
2	Door Post Block	0.405inches ± 0.010	0.415 0.395	0.408	
3	Door Post Block	100Degrees ± 0	100 100	100°	
4	Door Post Block	0.100inches ± 0.010	0.110 0.090	0.100	
5	Door Post Block	0.130inches ± 0.010	0.140 0.120	0.125	
6	Door Post Block	1.630inches ± 0.005	1.635 1.625	1.629	
7	Door Post Block	0.440inches ± 0.030	0.470 0.410	0.436	
8	Door Post Block	2.500inches ± 0.010	2.510 2.490	2.500	
9	Door Post Block	1.845inches ± 0.010	1.855 1.835	1.839	
10	Door Post Block	1.000inches ± 0.010	1.010 0.990	1.000	
11	Door Post Block	1.620inches ± 0.050	1.670 1.570	1.625	
12	Door Post Block	2.500inches ± 0.030	2.530 2.470	2.500	
13	Door Post Block	0.750inches ± 0.030	0.780 0.720	0.750	

Plex 5/9/19 1:33 PM Dart.lajeunesse.marie

DAS
52
9-89

19/05/31

S045598

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					